



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D3914-041
Job Sheet 185683



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Large Fab-5		<i>[Signature]</i> 20/11/18
100	Large Fab	1 pcs	11/23/18	11/23/18	0.00	6.67	Large Fab 1		<i>[Signature]</i> 20/11/18
110	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC9		<i>[Signature]</i> 20/11/18
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		<i>[Signature]</i> 20/11/18
130	Powdercoat	1 pcs	11/23/18	11/23/18	0.00	0.40	Powdercoat4		<i>[Signature]</i> 20/11/18
135	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC3		<i>[Signature]</i> 20/11/18
140	HandFinish	1 pcs	11/23/18	11/23/18	0.00	0.80	HandFinish3		<i>[Signature]</i> 20/11/18
150	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC3		<i>[Signature]</i> 20/11/18
160	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		<i>[Signature]</i> 20/11/18
170	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		<i>[Signature]</i> 20/11/18

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***

M138839 START: 10:45 TEMP: 320° FINISH: 11:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	S 108601
D3914-1 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 116508
D3914-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 115924
D4016-3 ✓	Hinge Half, Lid	3 Ea (3 ea) ✓	90-Start up Operation	S 121277
D4018-5 ✓	Rib	9 Ea (9 ea) ✓	90-Start up Operation	S 115926
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	S 113739
D4021-3 ✓	Data Plate	1 Ea (1 ea) ✓	90-Start up Operation	S 114284
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea) ✓	90-Start up Operation	S 123264

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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90-Start up Operation

D2581	2	42	0
D3914-1	2	2	0
D3914-7	2	4	0
D4016-3	3	219	0
D4018-5	9	24	0
D4020-5	1	4	0
D4021-3	1	22	0
D4035-043	2	2	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 11:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	

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 CANADA
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Container No: S129537
Part: D3914-041
Job No: 185683
Serial No/Batch: S129537
 Revision: A/D
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 11/20/18

Environ D Doc Equip/T Handli N Internal Tr Tribal Knowledge	LOA Substation Past Expiry Date Misidentified	Product Improvement Process Improvement Manufacturing Process Past Due	Wave / Twist Marks/Chatter Drill Holes	EGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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